

Date: Tuesday, 3/11/2008 1:17:27 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BLANKING PLATE		
Job Number	37815					
Estimate Number	13196					
P.O. Number			Part Number	D37571		
This Issue	3/11/2008	S.O. No. :	Drawing Number	D3757 REV A		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type : SMALL /MED FAB	Drawing Revision	A		
Previous Run			Material	:		
Written By	<i>JL</i>		Due Date	3/14/2008	Qty:	6 Um: Each
Checked & Approved By	<i>JL 08 03 11</i>					
Comment	Est Rev:A 08-01-30 new issue DD verified by:EC Est Rev:B 08-02-27 rev.A as per ecn 1139 DD verified by:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 .063 Sheet	
		Comment: Qty.: 0.0653 sf(s)/Unit Total : 0.3919 sf(s) 304 S.S sheet .063" thick (M304s063)	
	Batch: <i>106860</i>	<i>ml 08 03 12</i>	(6)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3757	
	Dwg Rev: <i>A</i>	<i>ml 08 03 12</i>	(6)
	Prog Rev: <i>A</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<i>ml 08 03 12</i>	(6)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<i>ml 08 03 12</i>	(6)
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		<i>ml 08 03 12</i>	(6)
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
	1- Debur if necessary		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 1:17:27 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLANKING PLATE

Job Number: 37815

Part Number: D37571

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



✓ 08/03/12 (6)

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



m/08/08/5



Fx 08/03/12 (6)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MJ



08-03-13

(X6)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 198

AS 08/03/13 (6)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

Do 08/03/14

Job Completion



mi 2008/3/13

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

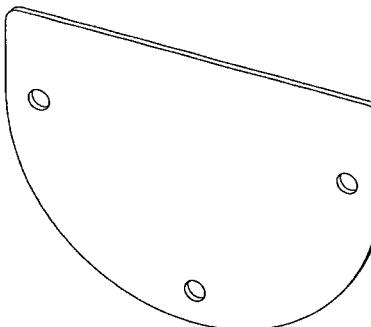
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D D
C C
B B
A A



D3757-1 BLANKING PLATE

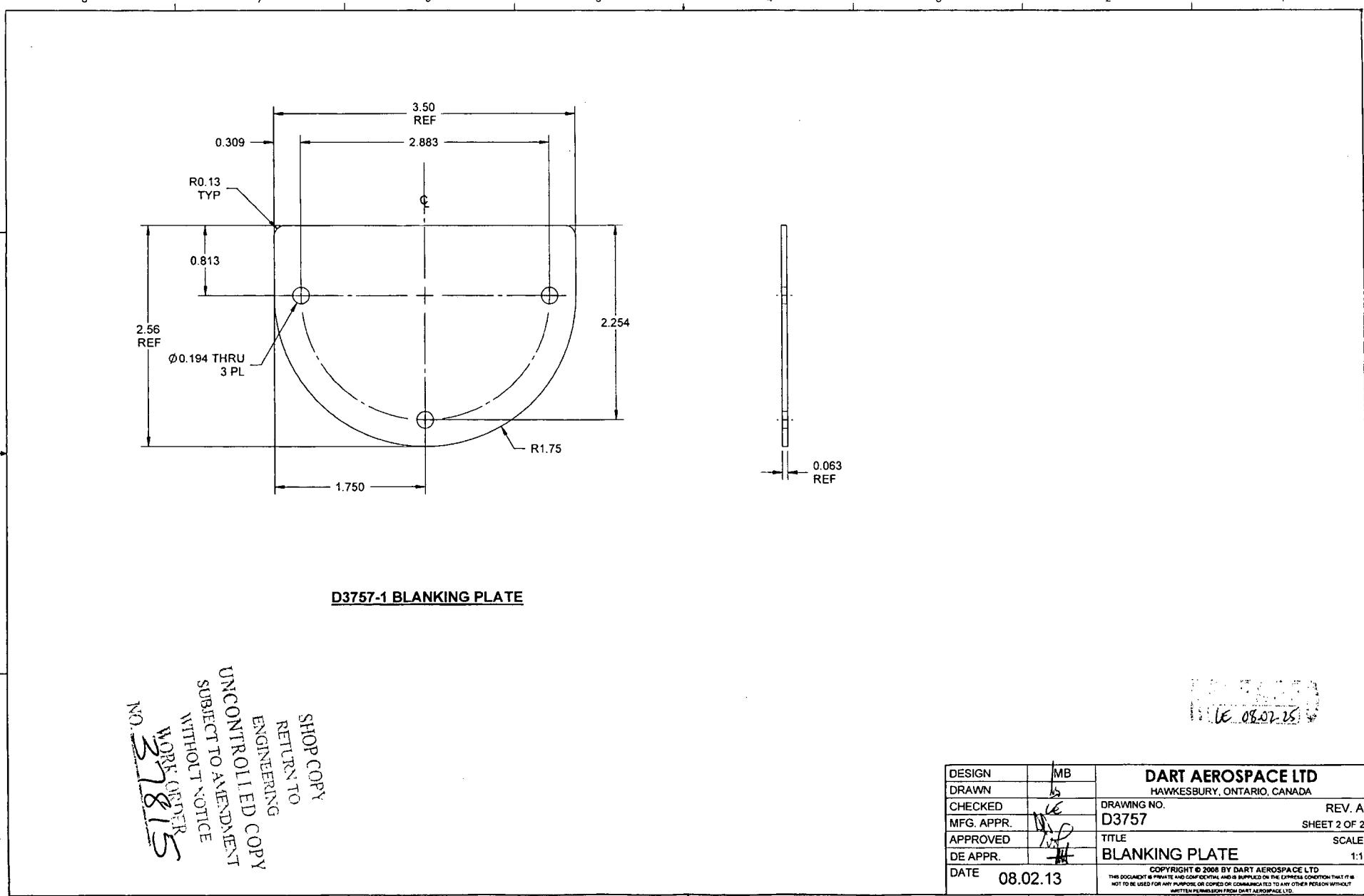
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
No. 37815

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
PER MIL-S-5059 (ANNEALED)
(REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3757-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

A	NEW ISSUE		MB	08.02.13
REV.	DESCRIPTION		BY	DATE
DESIGN	MB	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3757	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		BLANKING PLATE	1:1	
DATE	08.02.13		COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



DART AEROSPACE LTD	Work Order:	37815
Description: Blanking Plate.	Part Number:	D3751-1
Inspection Dwg: D3751 Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

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Measured by:	<u>M. M.</u>	Audited by:	<u>J</u>	Prototype Approval:	<u>✓</u>
Date:	08/03/12	Date:	08/03/12	Date:	07

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

